

Date: Friday, 28/11/2008 9:19:49 AM  
 User: Melanie Fauteux

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	BASKET MOD KIT
<b>Job Number</b> :	43835		
<b>Estimate Number</b> :	11337		
<b>P.O. Number</b> :		<b>Part Number</b> :	DSI9268011
<b>This Issue</b> :	28/11/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3230 REV B
<b>First Issue</b> :	//	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	35611	<b>Drawing Revision</b> :	B
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	<u>MF 08-11-28</u>	<b>Due Date</b> :	03/12/2008
<b>Comment</b> :	Est Rev:B 03.11.19 Kit redesignKJ/DS		

Qty: 1 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



*for JLD 08.12.02*



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP DSI 9288-011 CHG 002

*508/2/02*

2.0

M304TS0750W065

304 SQ Tube .75x.75x.065W



Comment: Qty.: 25.8300 f(s)/Unit Total: 25.8300 f(s)

Material: 304/316 SS Tube 0.065" wall

(M304TS0.750W.065)

Batch: *M108846 → 5.52*

*M110011 → 16'*

*M109731 → 3.83'*

*PL 08.12.01*

3.0

D23273

Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description

2 D2327-3

Spacer Bushing

Batch

*339560*

*PL 08.12.01*

4.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 5.2500 sf(s)/Unit Total: 5.2500 sf(s)

Pick:

Qty Part Number Description

5sf M304EX0.75-16F Mesh

Batch

*M109383*

*PL 08.12.01*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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She ASAP  
Process Sheet

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Drawing Name: BASKET MOD KIT

Job Number: 43835

Part Number: DSI9268011

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4 x 3/4 square tubing as per Dwg D3230

(X1)

2-Fabricate basket wedge assembly as per D3230

A/R SS ROD Batch: M106762

2-Deburr & Remove all Markings From Material

CPL 08.12.01

6.0 DO NOT USE WELD INSPECTION



QC9 08/12/02



(P70)

Comment: WELD INSPECTION

QC5 08.12.02 (1)

7.0 POWDER COATING POWDER COATING



M109152



(1X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:15 OF  
400  
10:45

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:00 OF  
400  
11:30

M-L 08/12/02

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



(P)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 08/12/02


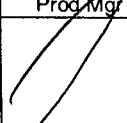
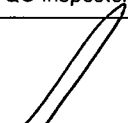
9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector
06-12-02	6.0	QCA : QCS required. perm change		07/12/02		 06-12-02	 06-12-02

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: BASKET MOD KIT

Job Number: 43835

Part Number: DSI9268011

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN417A

Bolt



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

5 AN4-17A Bolt M102280

8/12/2 SC

11.0

AN960JD416

Washer



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

5 AN960JD416 Washer M109249

8/12/2 SC

12.0

MS21042L4

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

5 MS21042L4 Nut (or -4) M108145

8/12/2 SC

13.0

DSI9053011

SEE DSI 9053011



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 DSI 9053-011 Hinge Change Kit 21889

8/12/2 SC

14.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8/06/12/02 80

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: DSI9268011

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP Dsi 9268-011

Location: \_\_\_\_\_

PPP Rev: A

8/12/02

SP

16.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/02

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

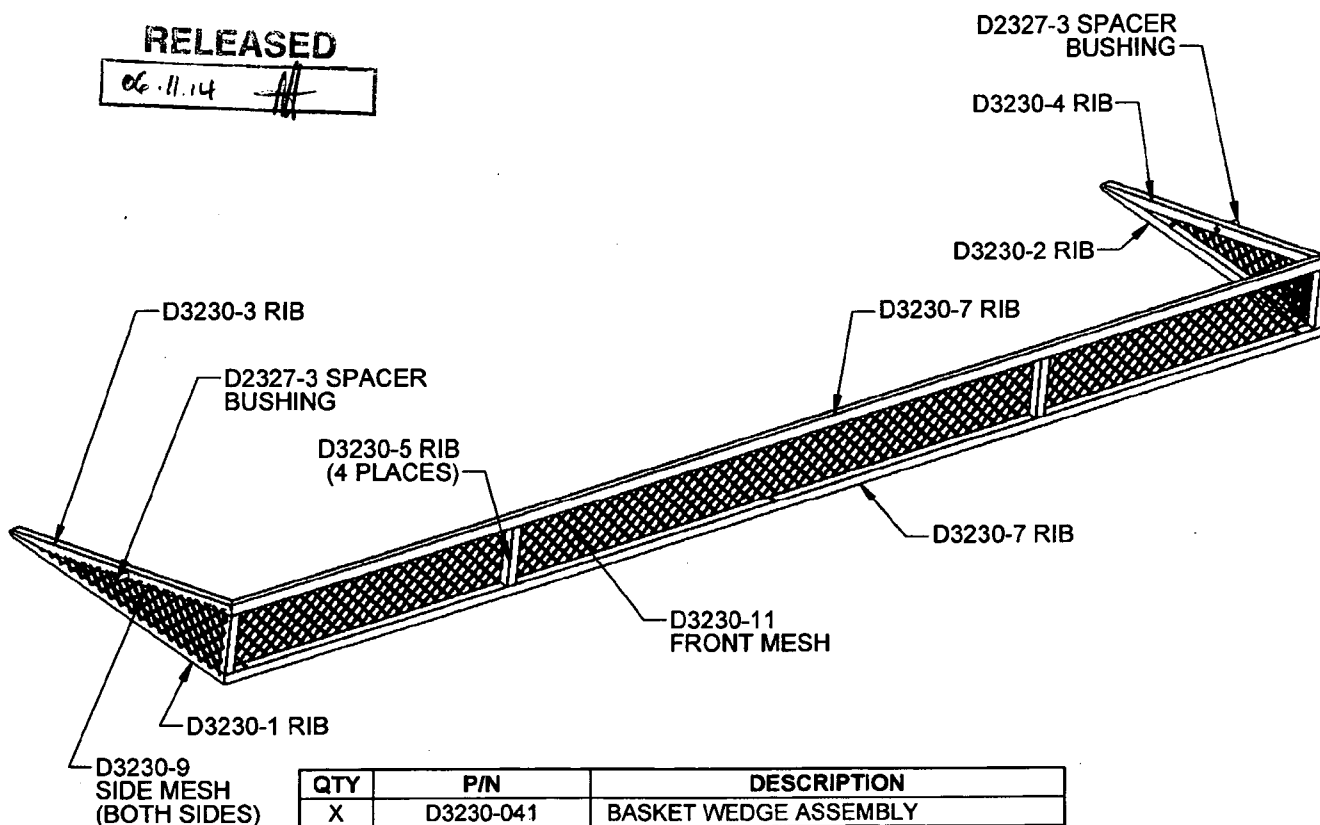
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**DART**

DESIGN <i>GP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>HA</i>	DRAWING NO. <b>D3230</b>	REV. B SHEET 1 OF 4
DATE <b>06.11.10</b>		TITLE <b>BASKET WEDGE ASSEMBLY</b>	SCALE 1:32
REV	DATE	DESCRIPTION	
A	03.10.31	NEW ISSUE	
B	06.11.10	15.75 WAS 16.00; REMOVE D2581; ADD VIEW B-B; D2327-3 ADDED	

**RELEASED**06.11.14 *HA*

QTY	P/N	DESCRIPTION
X	D3230-041	BASKET WEDGE ASSEMBLY
2	D2327-3	SPACER BUSHING
1	D3230-1	RIB
1	D3230-2	RIB
1	D3230-3	RIB
1	D3230-4	RIB
4	D3230-5	RIB
2	D3230-7	RIB
2	D3230-9	SIDE MESH
1	D3230-11	FRONT MESH

*Mo 43835***NOTES:**

- 1) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT  $\phi$

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

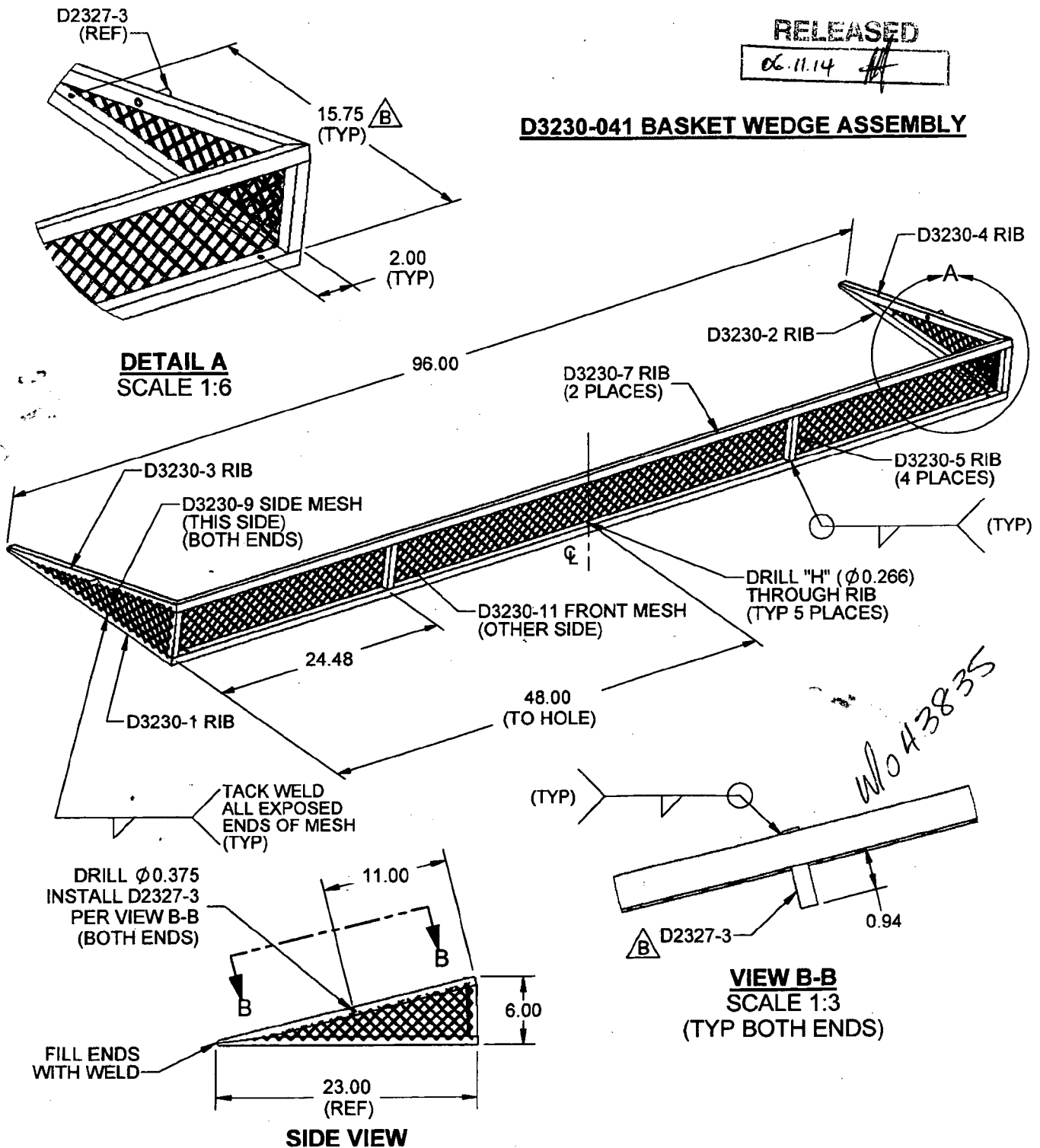
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NOTE: Date & initial all entries

**DART**

DESIGN <i>qp</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3230</b>	REV. B SHEET 2 OF 4
DATE <b>06.11.10</b>	TITLE <b>BASKET WEDGE ASSEMBLY</b>		SCALE 1:12

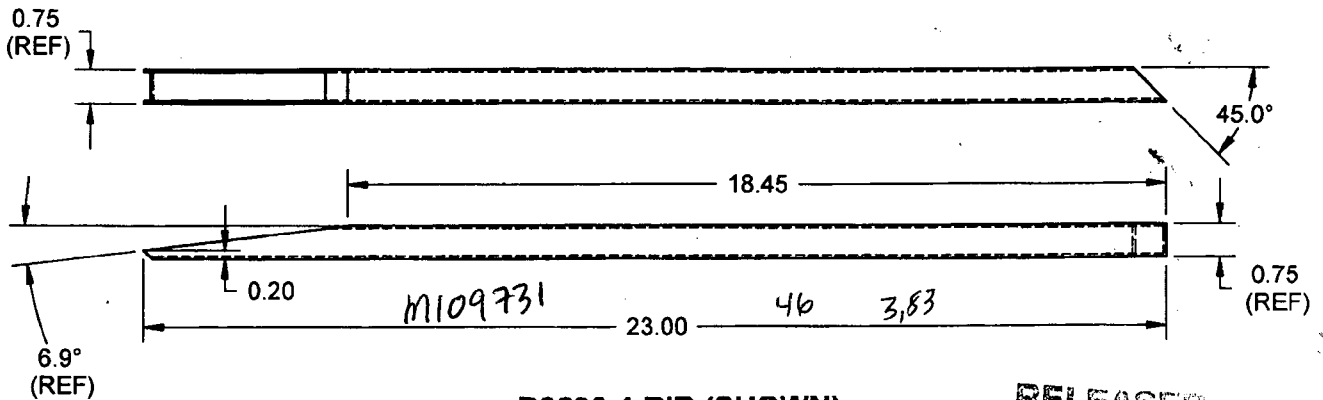
**RELEASED**06.11.14 *H***D3230-041 BASKET WEDGE ASSEMBLY**

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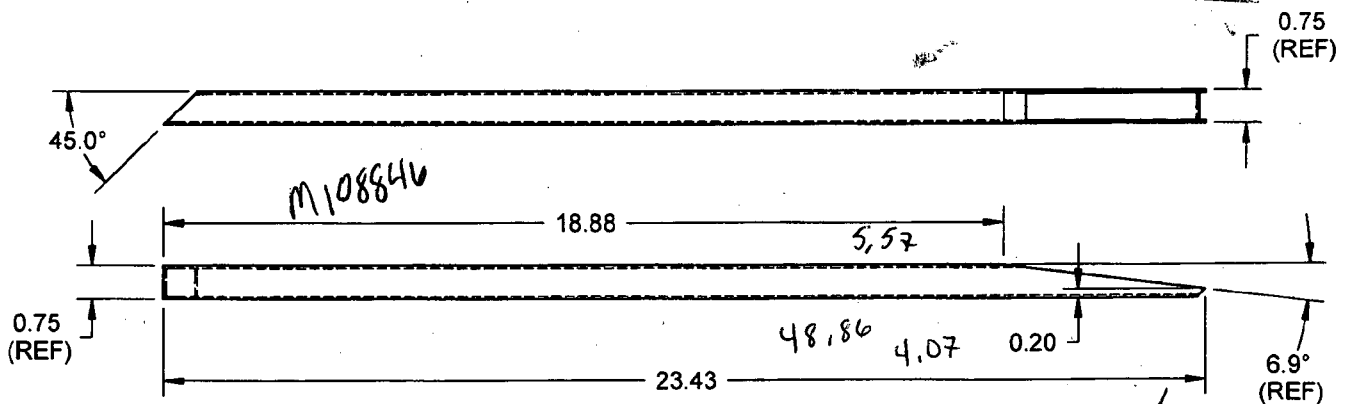
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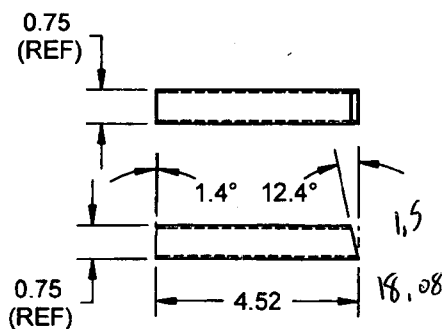
DESIGN <i>qp</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3230	REV. B SHEET 3 OF 4
DATE 06.11.10		TITLE BASKET WEDGE ASSEMBLY	SCALE 1:4



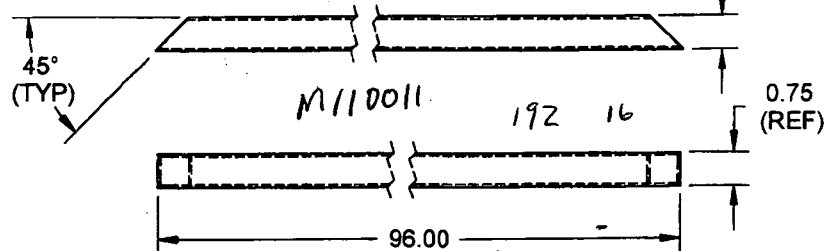
**D3230-1 RIB (SHOWN)**  
**D3230-2 RIB (OPPOSITE)**



**D3230-3 RIB (SHOWN)**  
**D3230-4 RIB (OPPOSITE)**



**D3230-5 RIB**



**D3230-7 RIB**

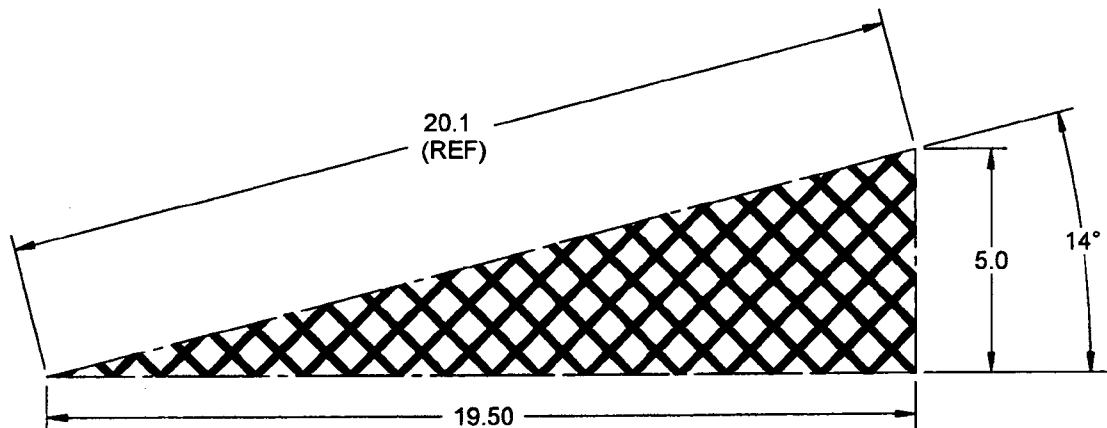
NOTE:  
RIB MATERIAL: AISI 304/316 STAINLESS STEEL, 0.75 x 0.75 x 0.06 THICK SQUARE TUBING  
(REF DART SPEC M304TS0.750W.060)

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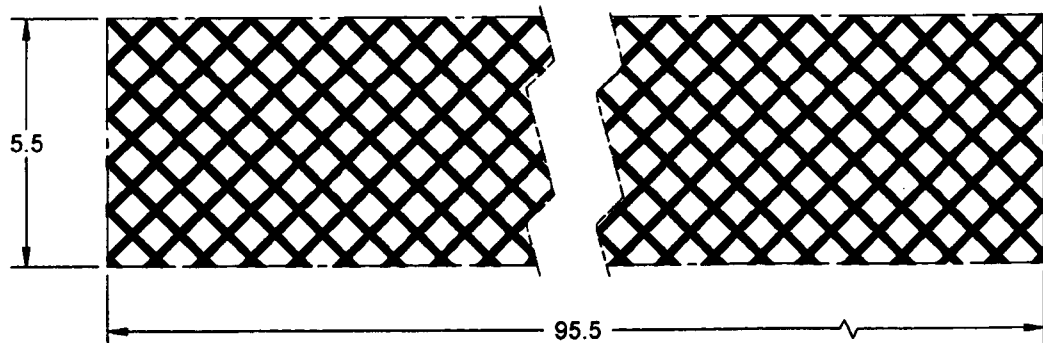


DESIGN <i>qp</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3230	REV. B SHEET 4 OF 4
DATE 06.11.10		TITLE BASKET WEDGE ASSEMBLY	SCALE 1:4



**D3230-9 SIDE MESH**

RELEASED  
06.11.14 *[Signature]*



**D3230-11 FRONT MESH**

*nb43835*

NOTE:  
MESH MATERIAL: 3/4 - 16F EXPANDED STAINLESS STEEL (REF DART SPEC M304EX0.75-16F)

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